

30. (Amended) A method of detecting defects on shot cores or core packets used in the foundry industry comprising the steps of

illuminating each shot core or core packet by at least two light sources from different directions,

recording by means of a camera each illuminated shot core or core packet and the shadows resulting from the illumination to thereby produce recorded data which comprise a recorded image, and

processing the recorded data in a computer, and including processing the recorded image by comparing the recorded image with a record of reference data.

34. (Amended) The method of claim 30, comprising the further step of performing a qualitative or quantitative image evaluation on the recorded image.

36. (Amended) The method of Claim 30, wherein the comparing step includes a coarse correlation with the recorded data.

37. (Amended) The method of Claim 30, wherein the recording step includes recording at least two images which are processed in the processing step.

42. (Amended) The method of Claim 30, wherein the image processing step comprises a defect detection.

Add the following new Claims 45-47:

45. (New) A method of detecting defects on shot cores or core packets used in the foundry industry comprising the steps of

illuminating each shot core or core packet by at least two light sources from different directions,

recording by means of a camera each illuminated shot core or core packet and the shadows resulting from the illumination to thereby produce recorded data which comprise a recorded image, and

processing the recorded data in a computer and including processing the recorded image by comparing the recorded image with a record of reference data, and

wherein the processing step further includes a brightness adjustment for adapting the gray-scale values of the image.

46. (New) The method of Claim 30, wherein the at least two light sources are operated in sequence.

47. (New) The method of Claim 30, wherein the at least two light sources are operated with color differentiation.

---